

**Fig. 2B**

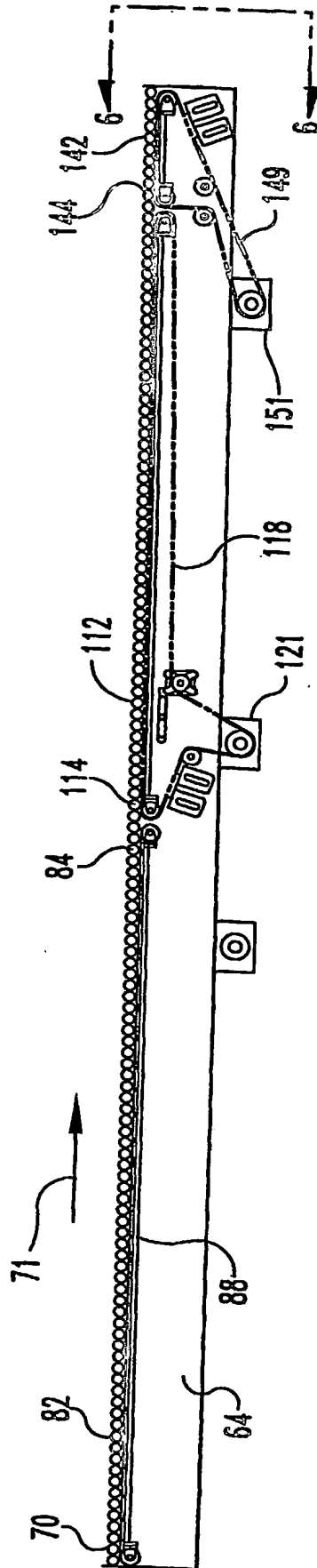


Fig. 4

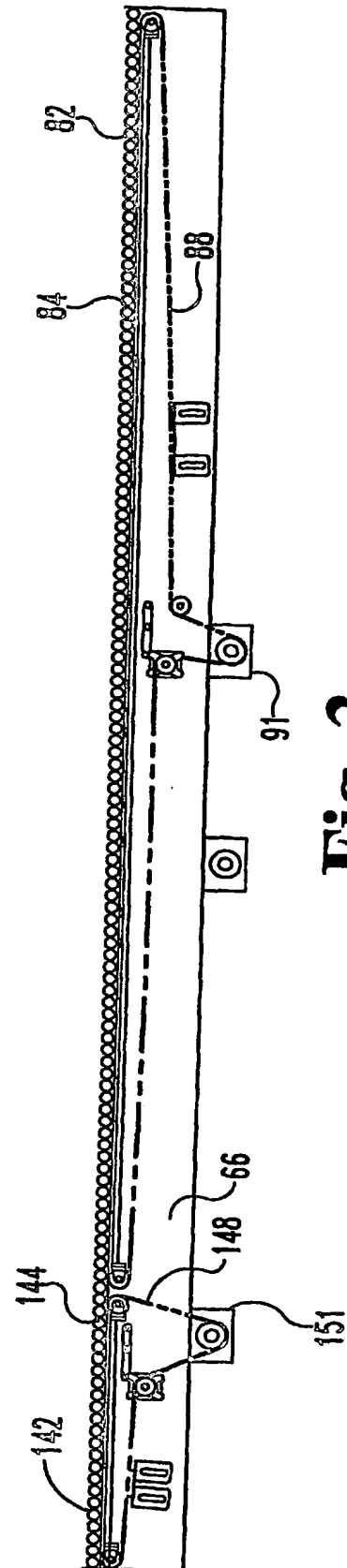
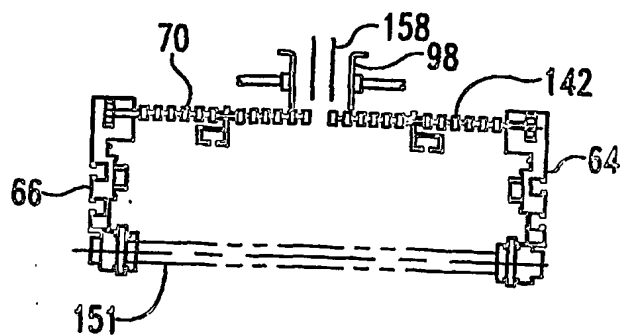
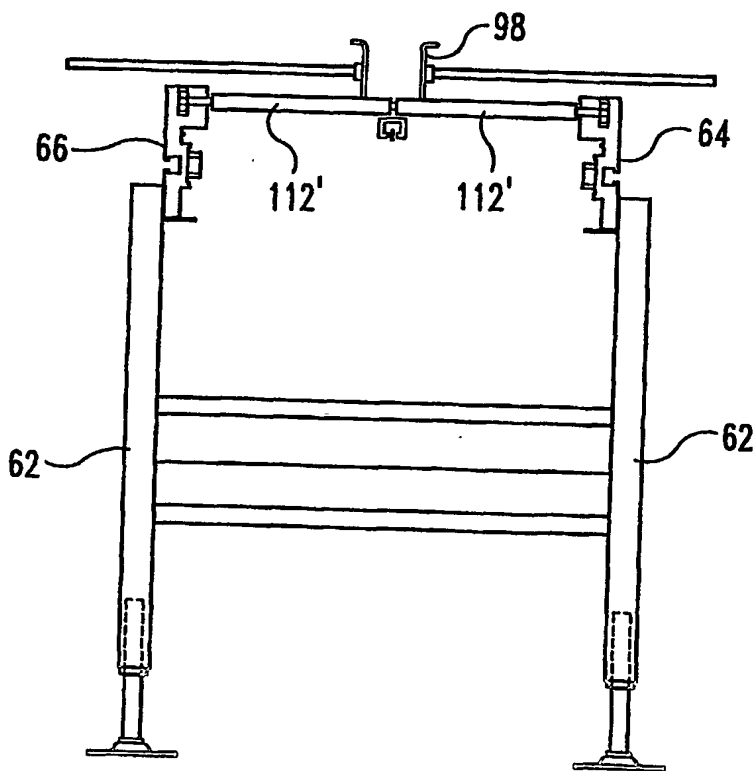


Fig. 3

4/21

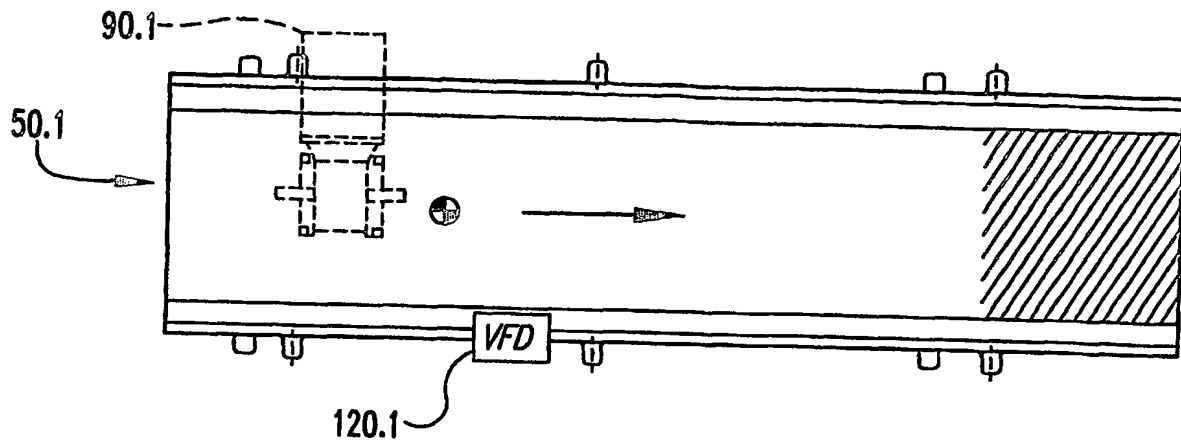


**Fig. 6**

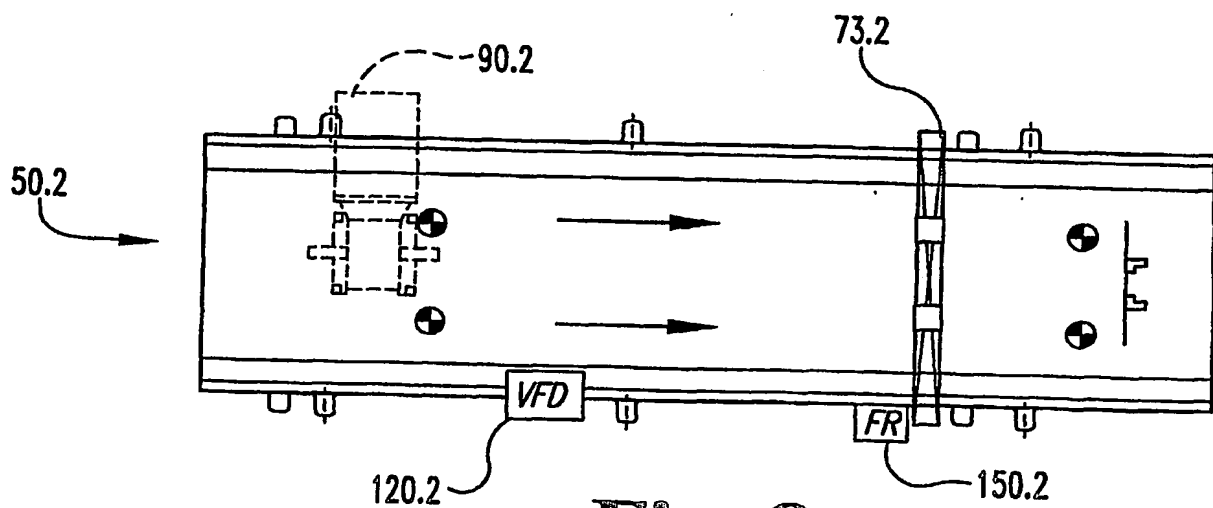


**Fig. 5**

5/21

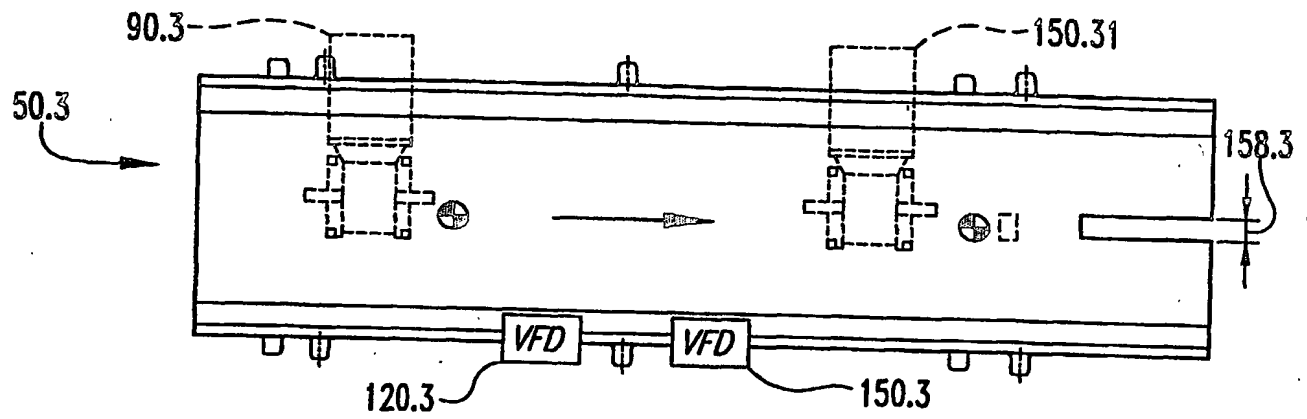


**Fig. 7**

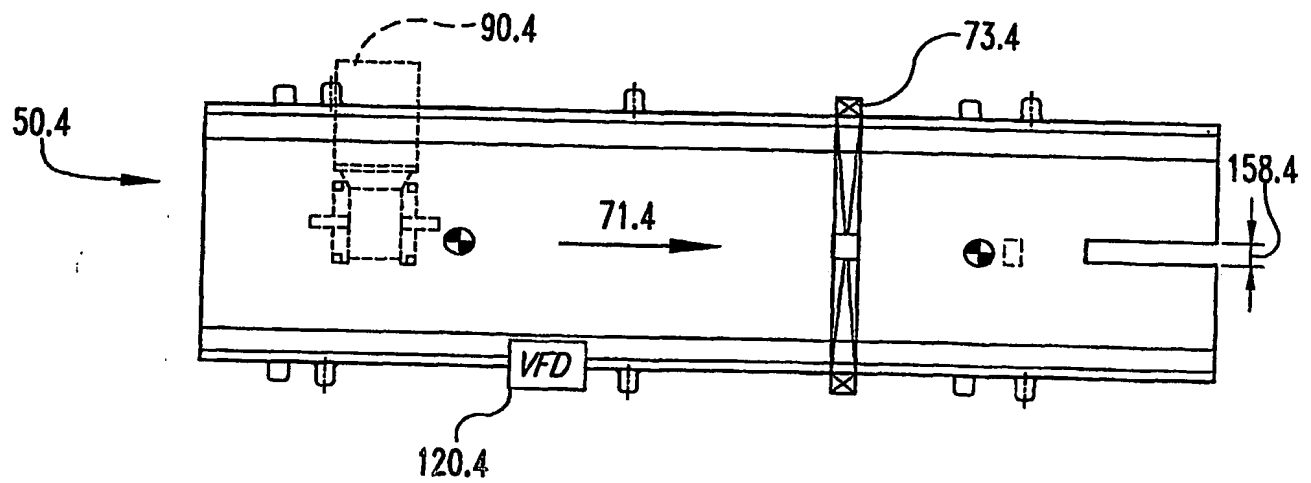


**Fig. 8**

6/21



**Fig. 9**



**Fig. 10**

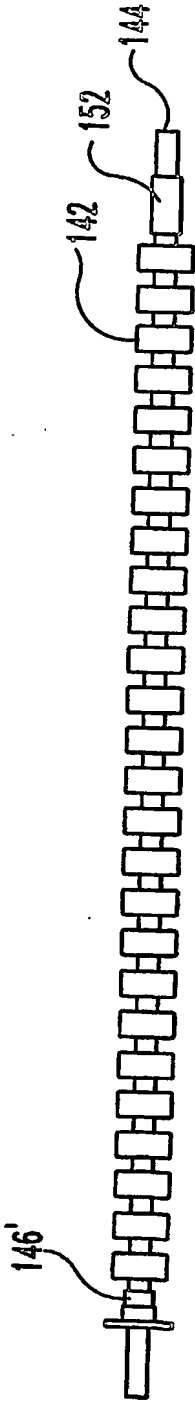


Fig. 11

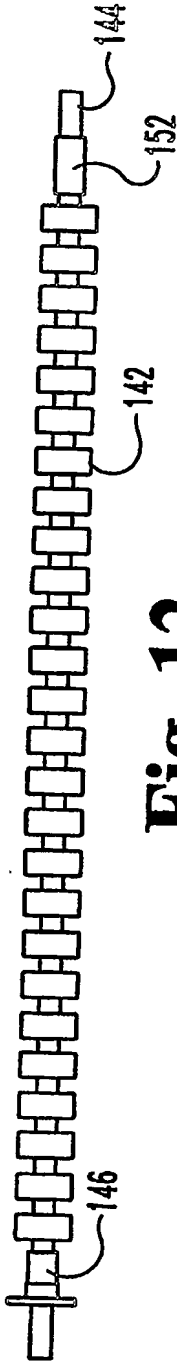


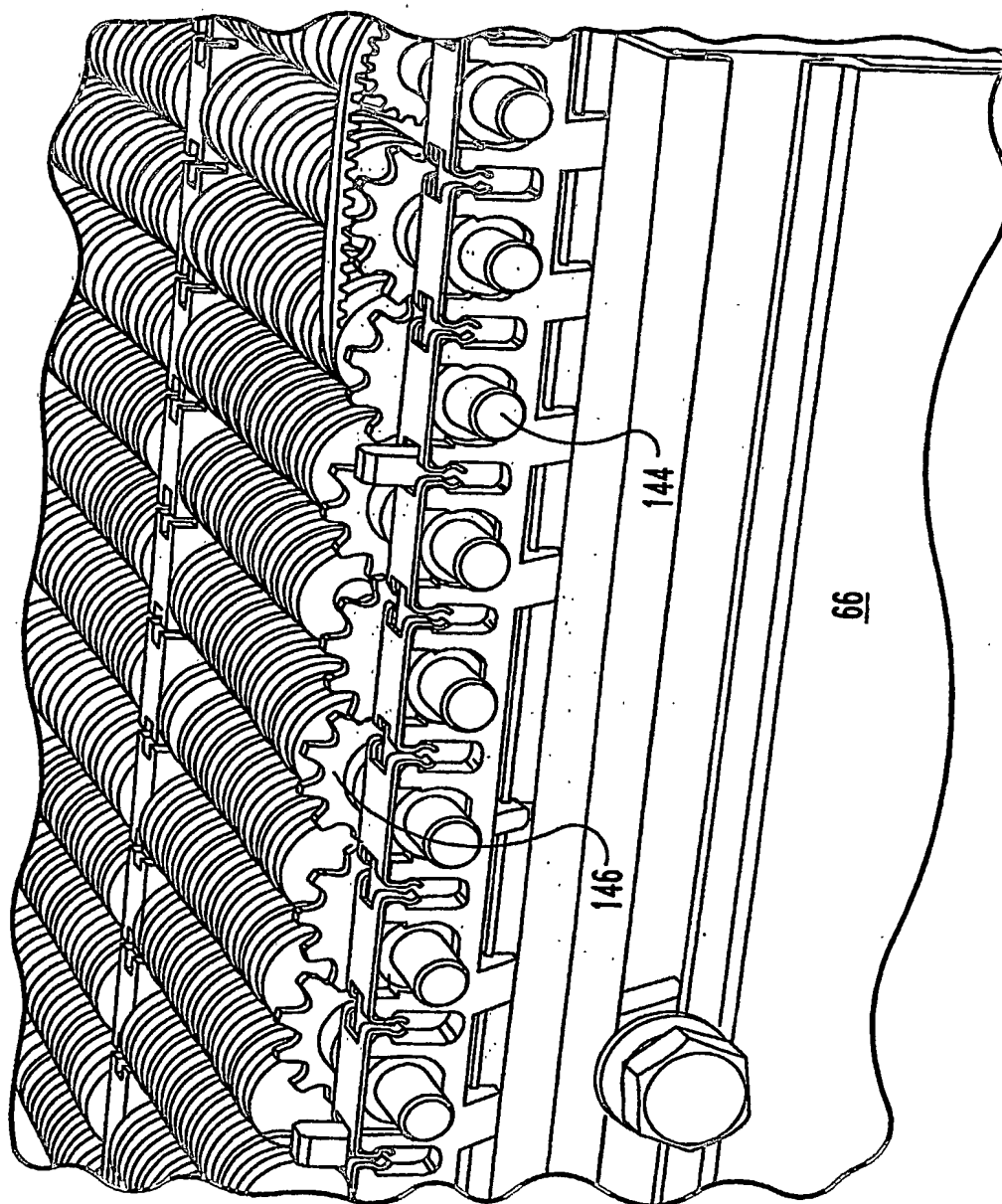
Fig. 12

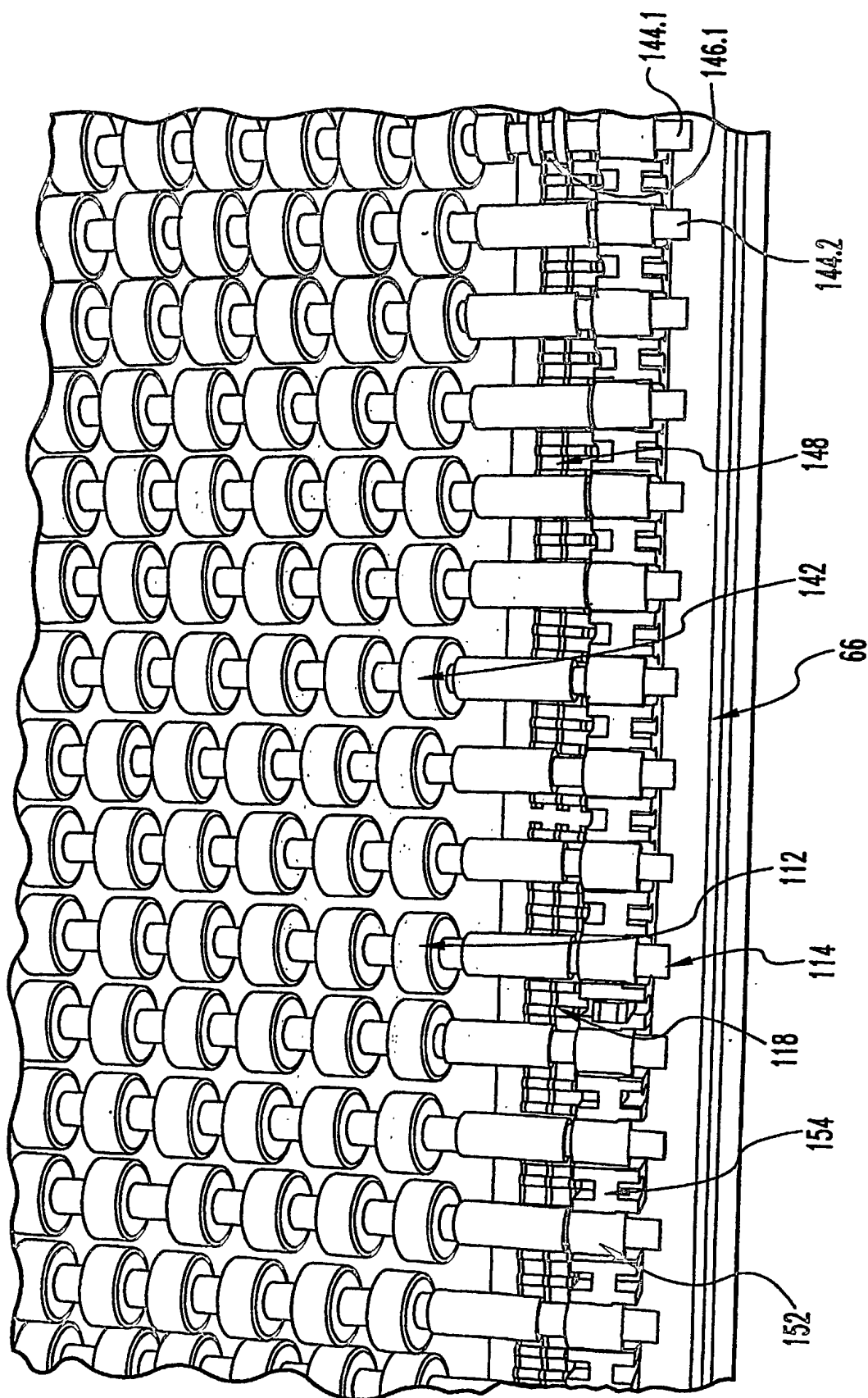




9/21

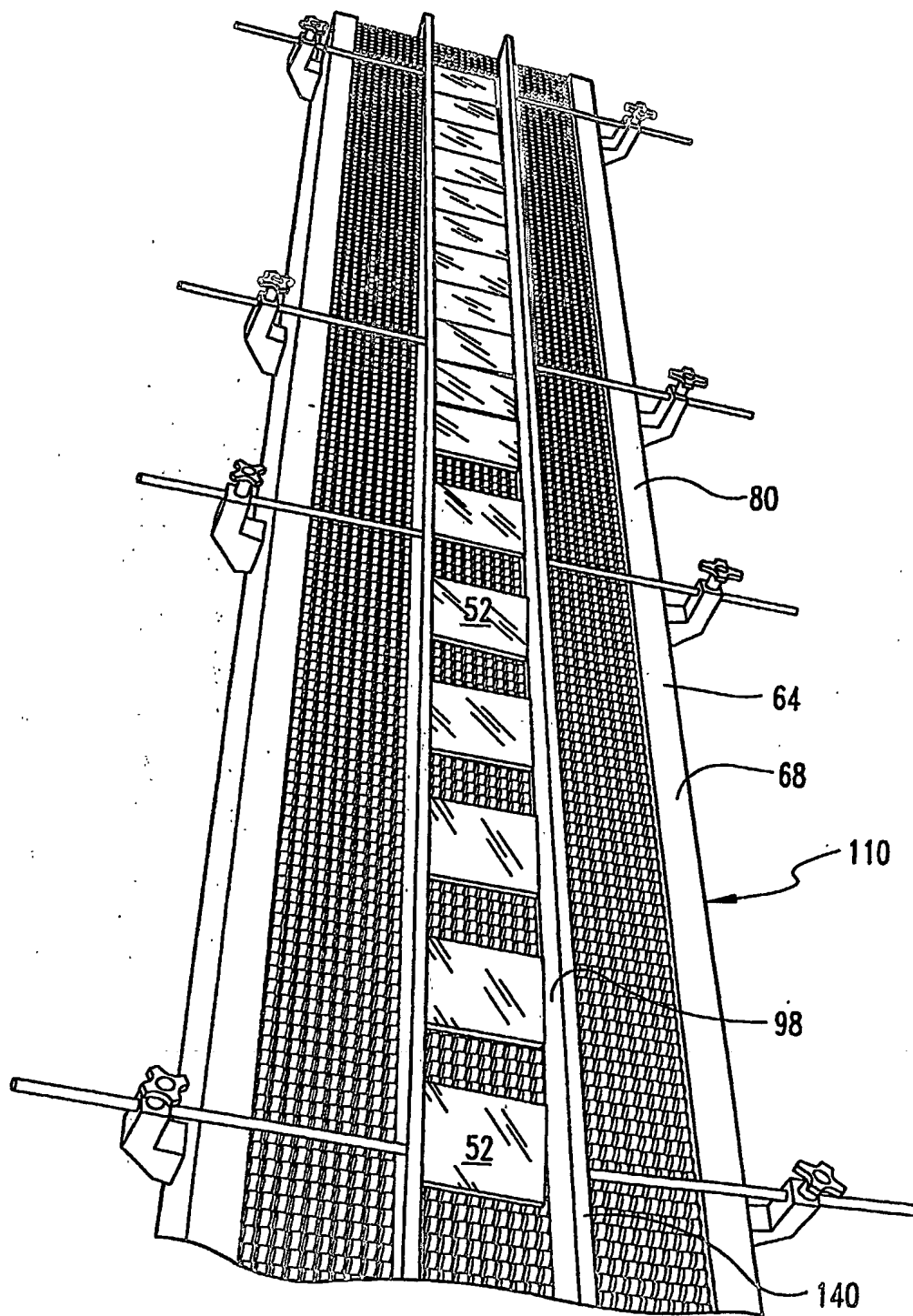
Fig. 14





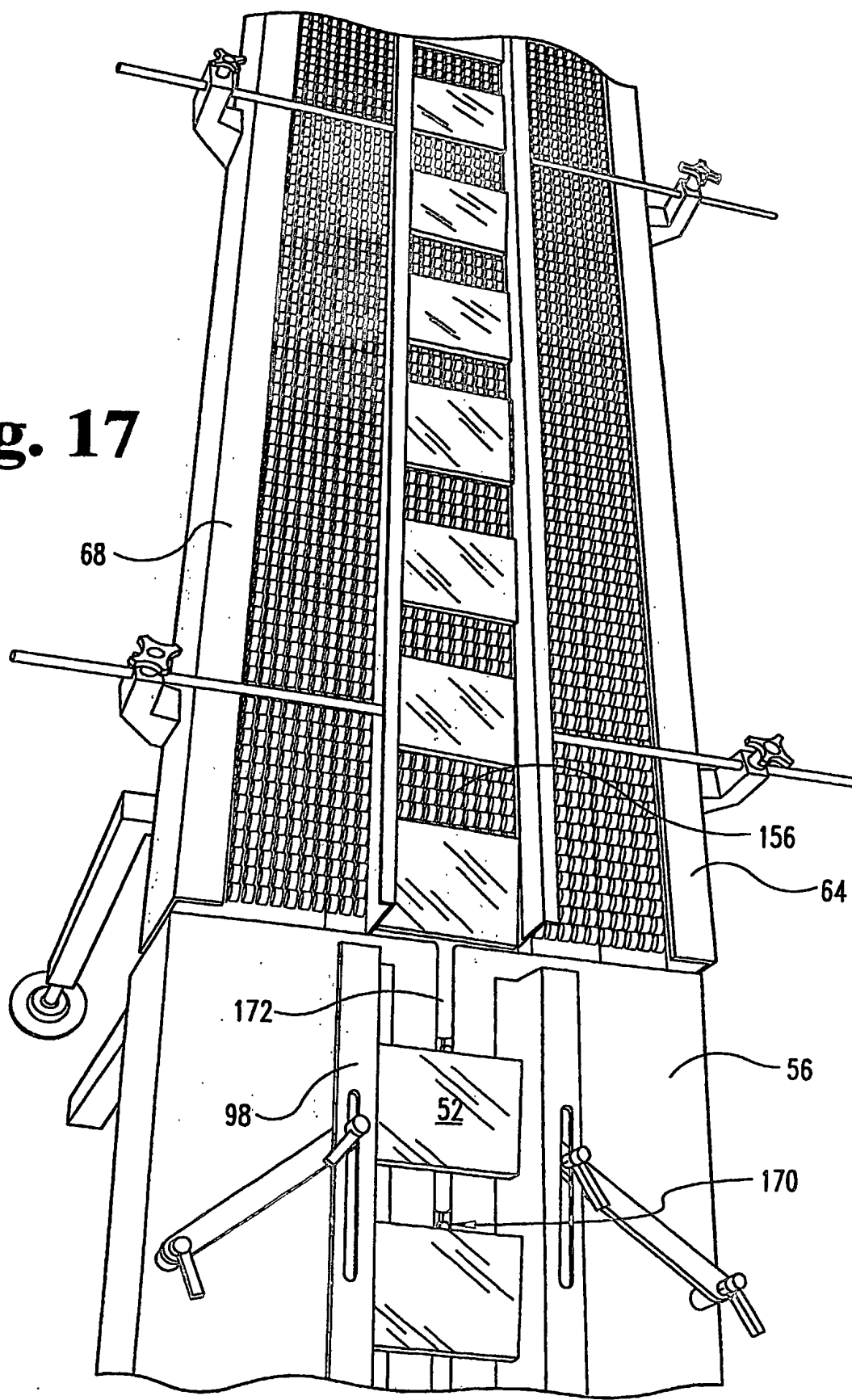
**Fig. 15**

11/21

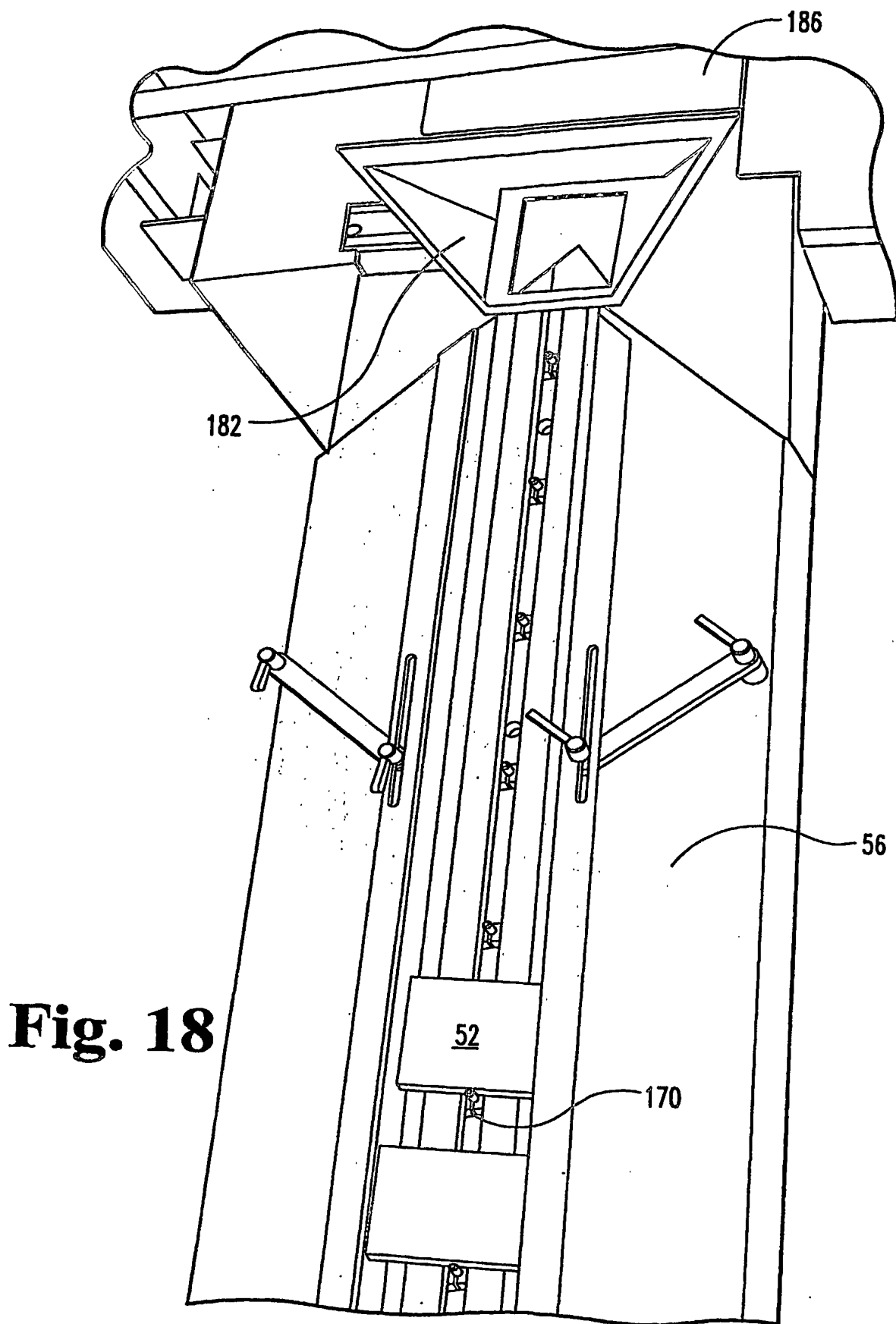


**Fig. 16**

**Fig. 17**



13/21



**Fig. 18**

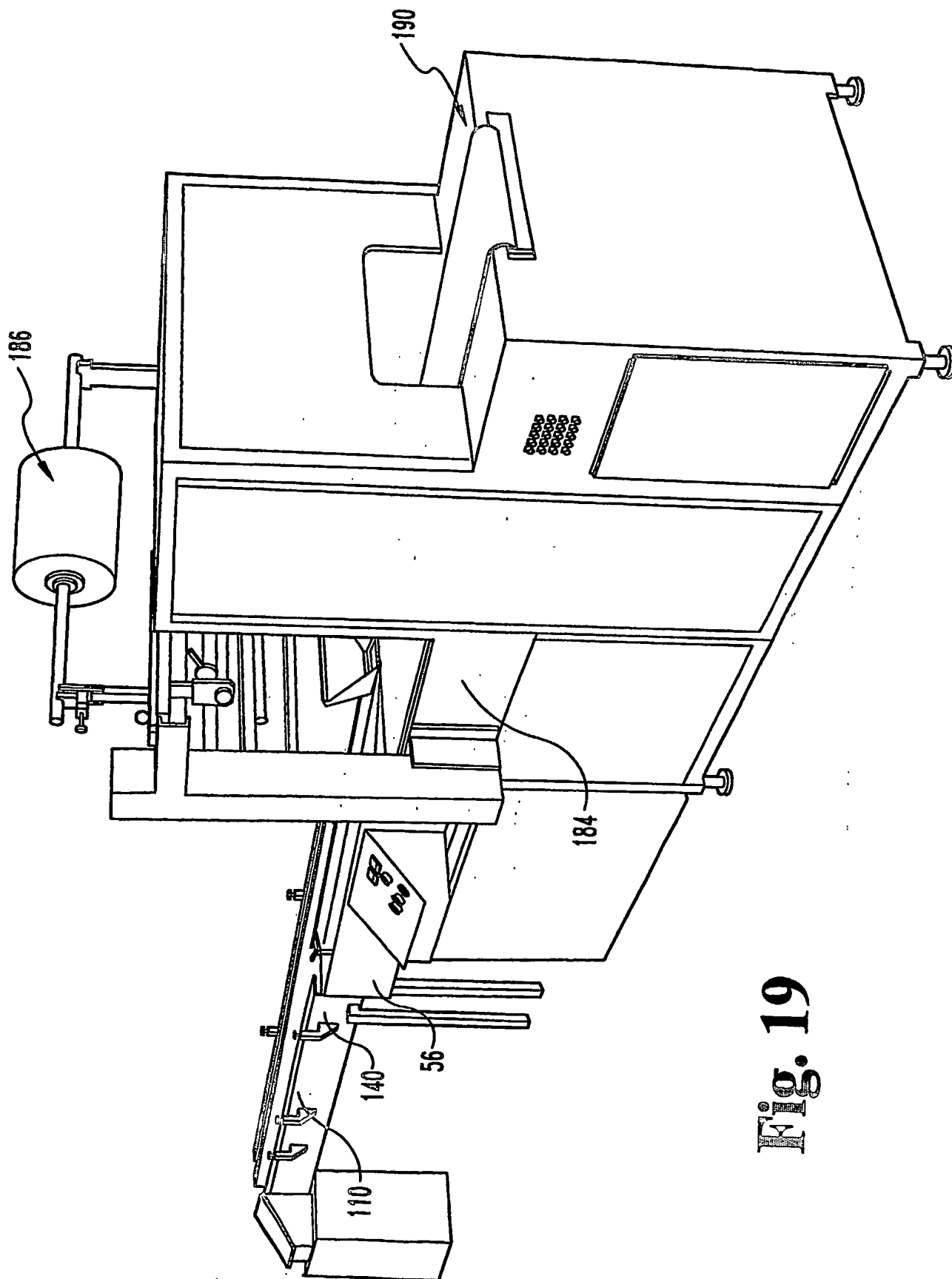
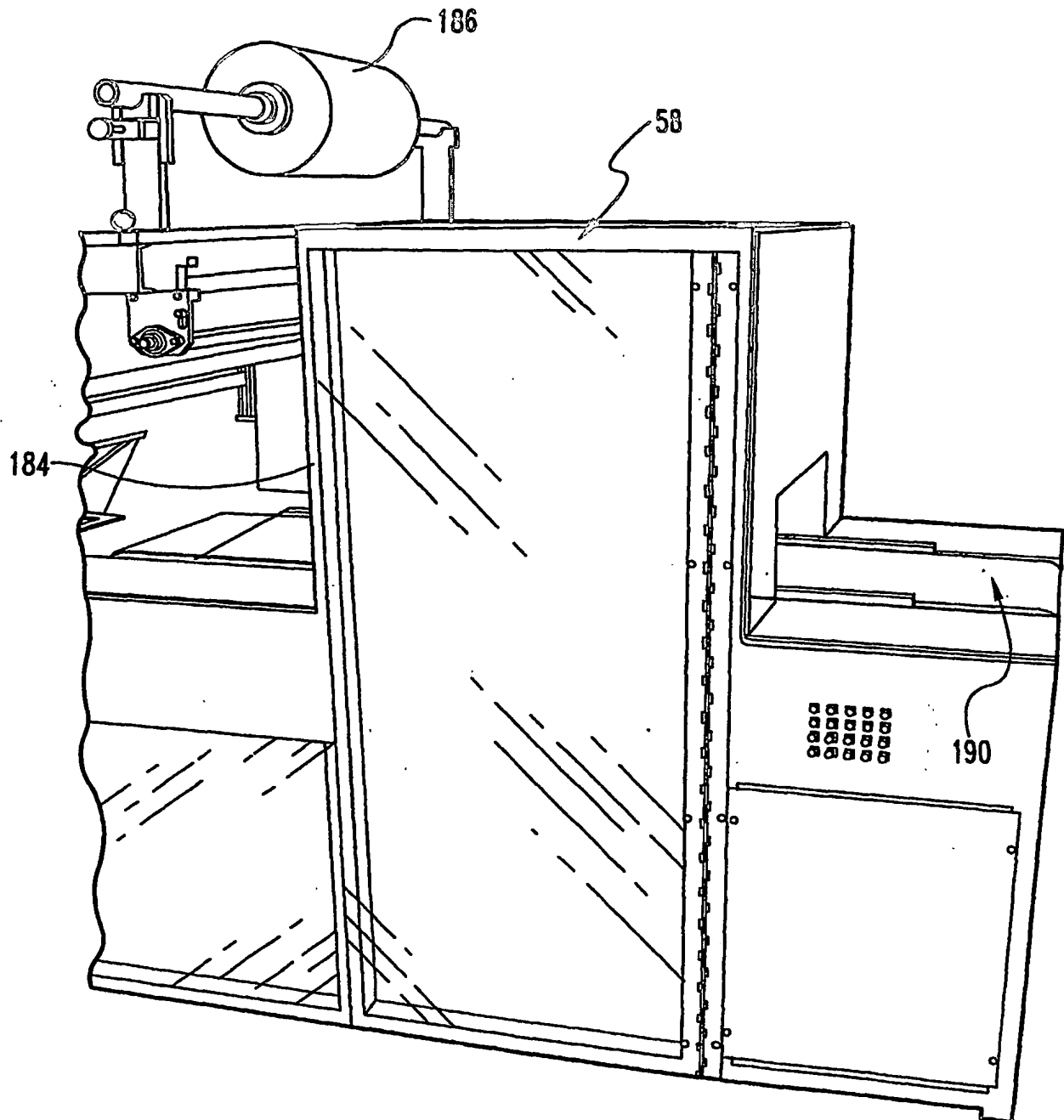


Fig. 19



**Fig. 20**

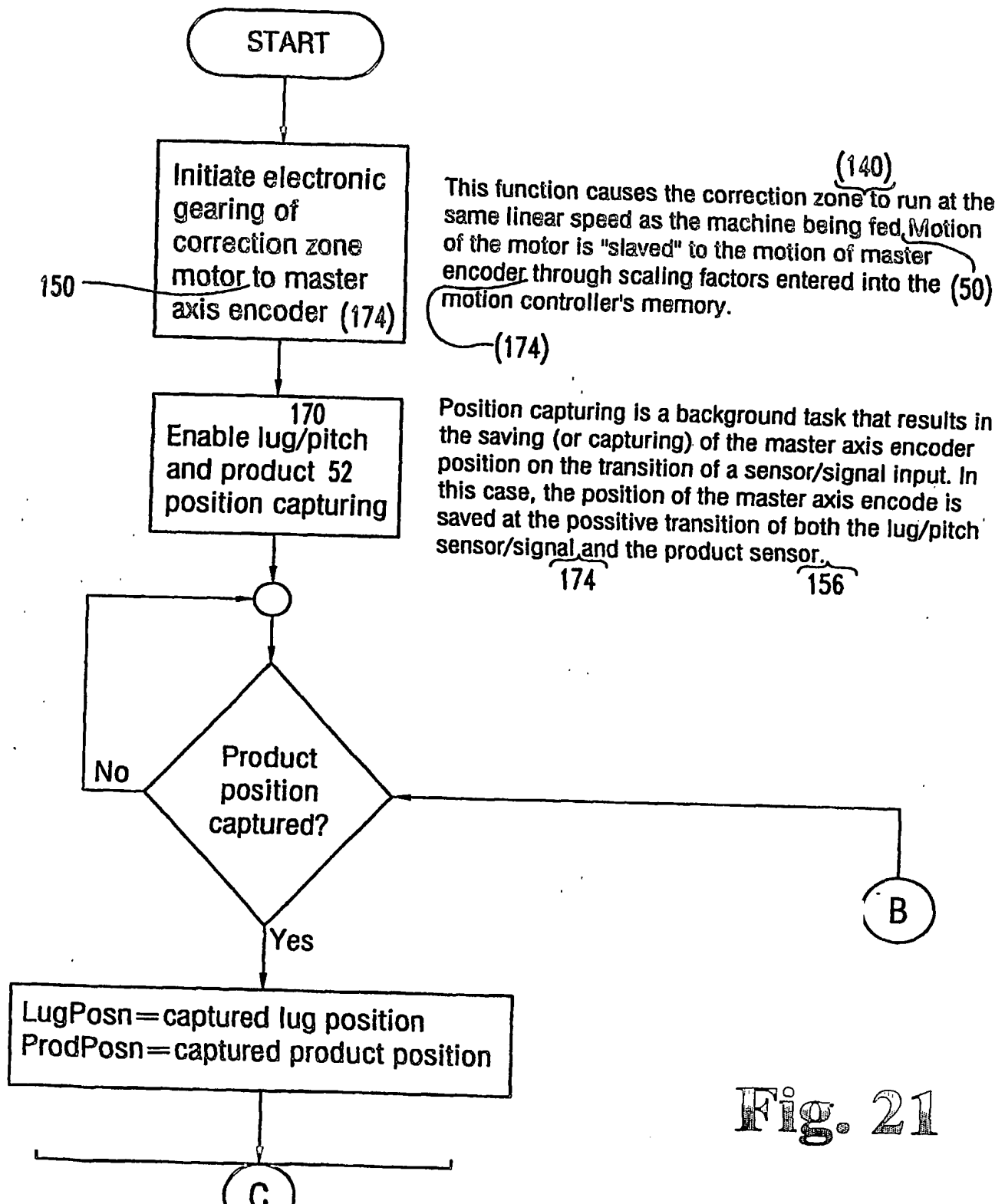
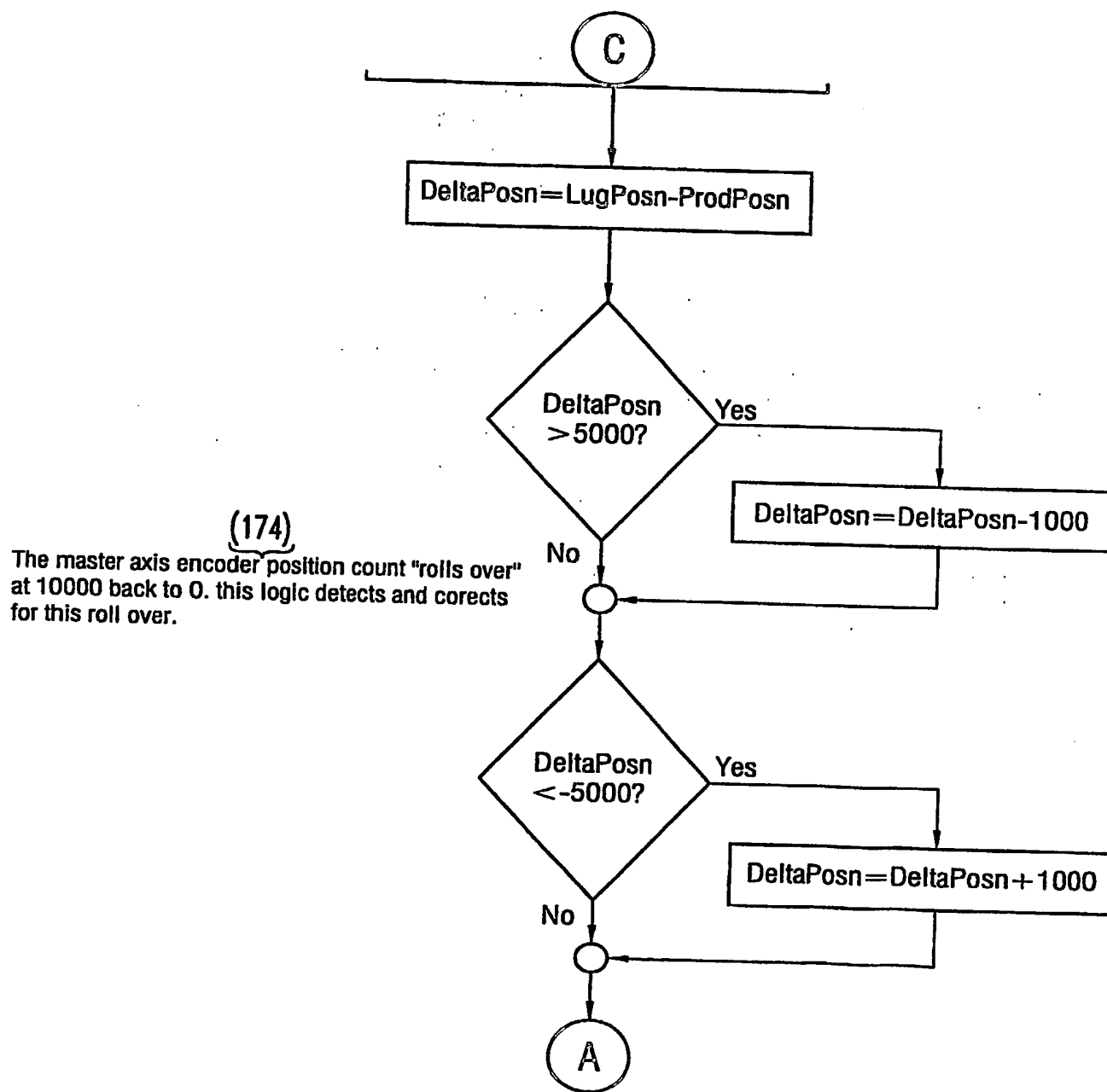


Fig. 21



17/21

**Fig. 22**

18/21

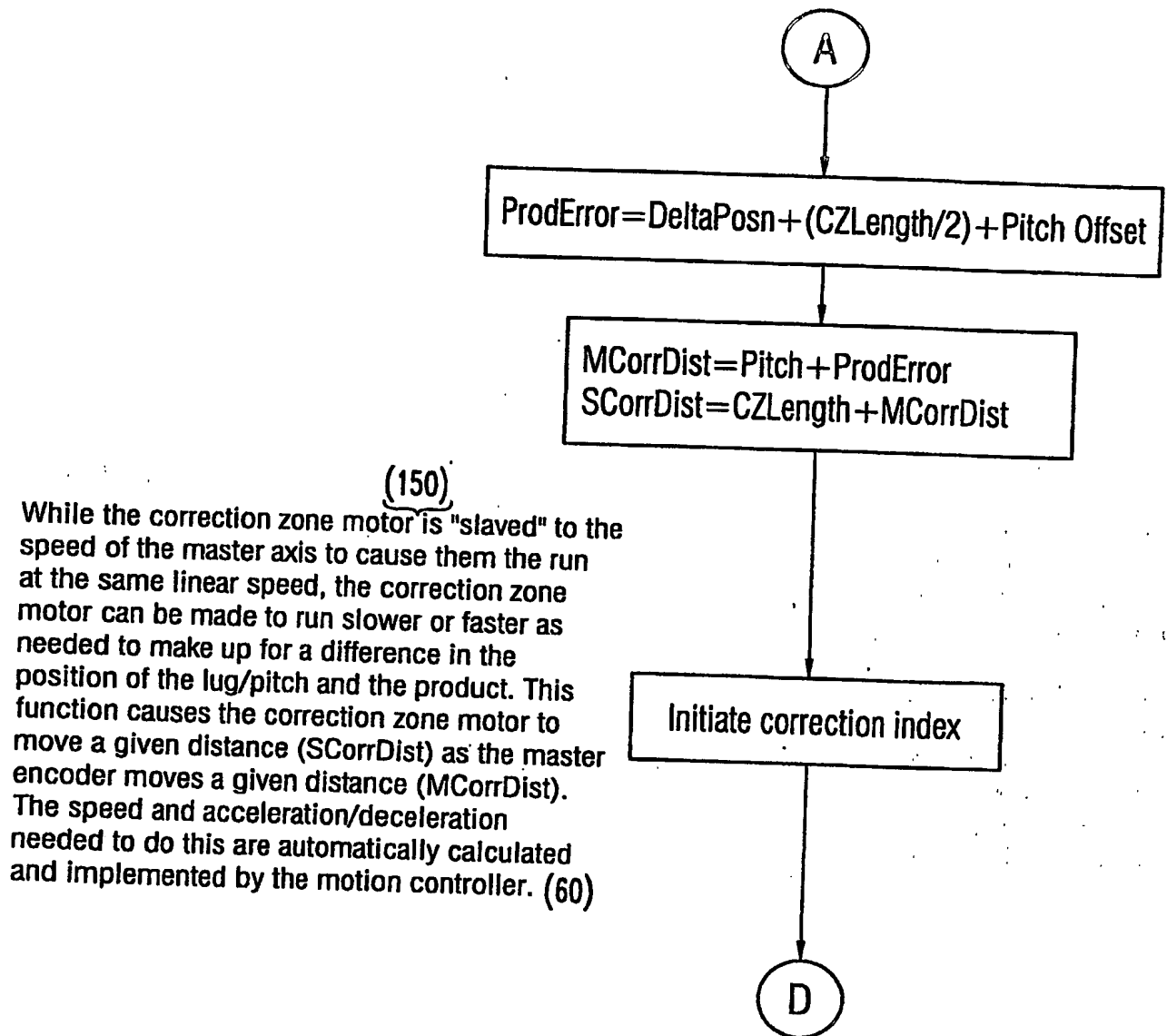
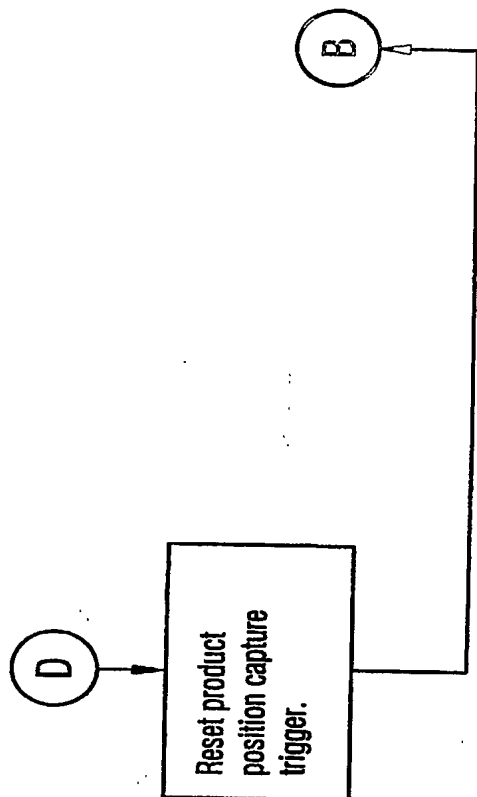


Fig. 23



Whenever a position capture is triggered, the trigger must be reset before another capture can occur. The lug/pitch position capture trigger is automatically reset on the negative transition to the lug/pitch sensor/signal. The product position capture trigger is programmatically reset here.

# Fig. 24

## Variable Description

CZLength: Correction zone length (in inches) entered via the OPI.

Pitch: Distance between lugs/pitch marks (in inches) entered via the OPI.

LugPosn: Position (in encoder counts) of the lug/pitch mark.

ProdPosn: Position (in encoder counts) of the product.

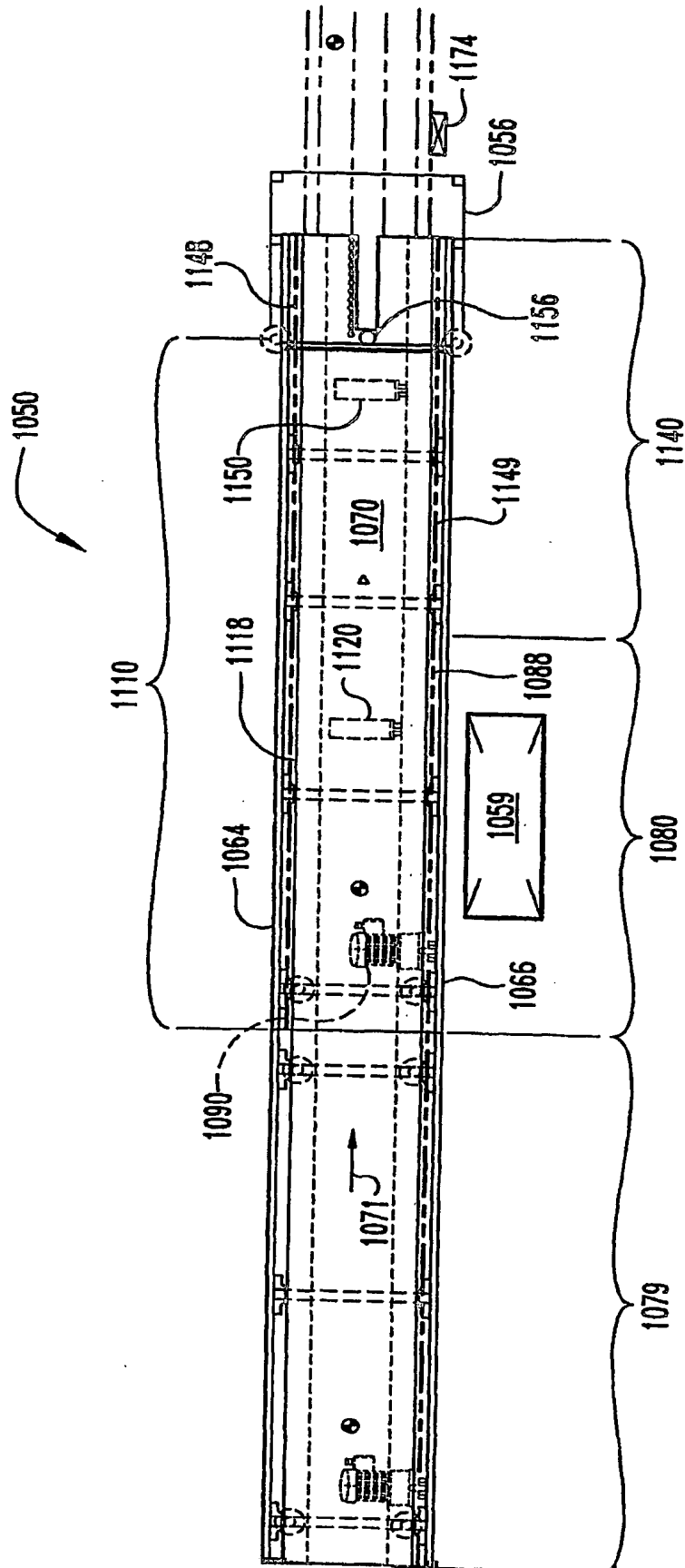
DeltaPosn: Difference between LugPosn and ProdPosn. Distance (in inches) that the product leads/lags the lug/pitch mark.

ProdError: Product position error. Distance (in inches) that the product needs to be advanced/retarded so that it can match the position of the lug/pitch mark.

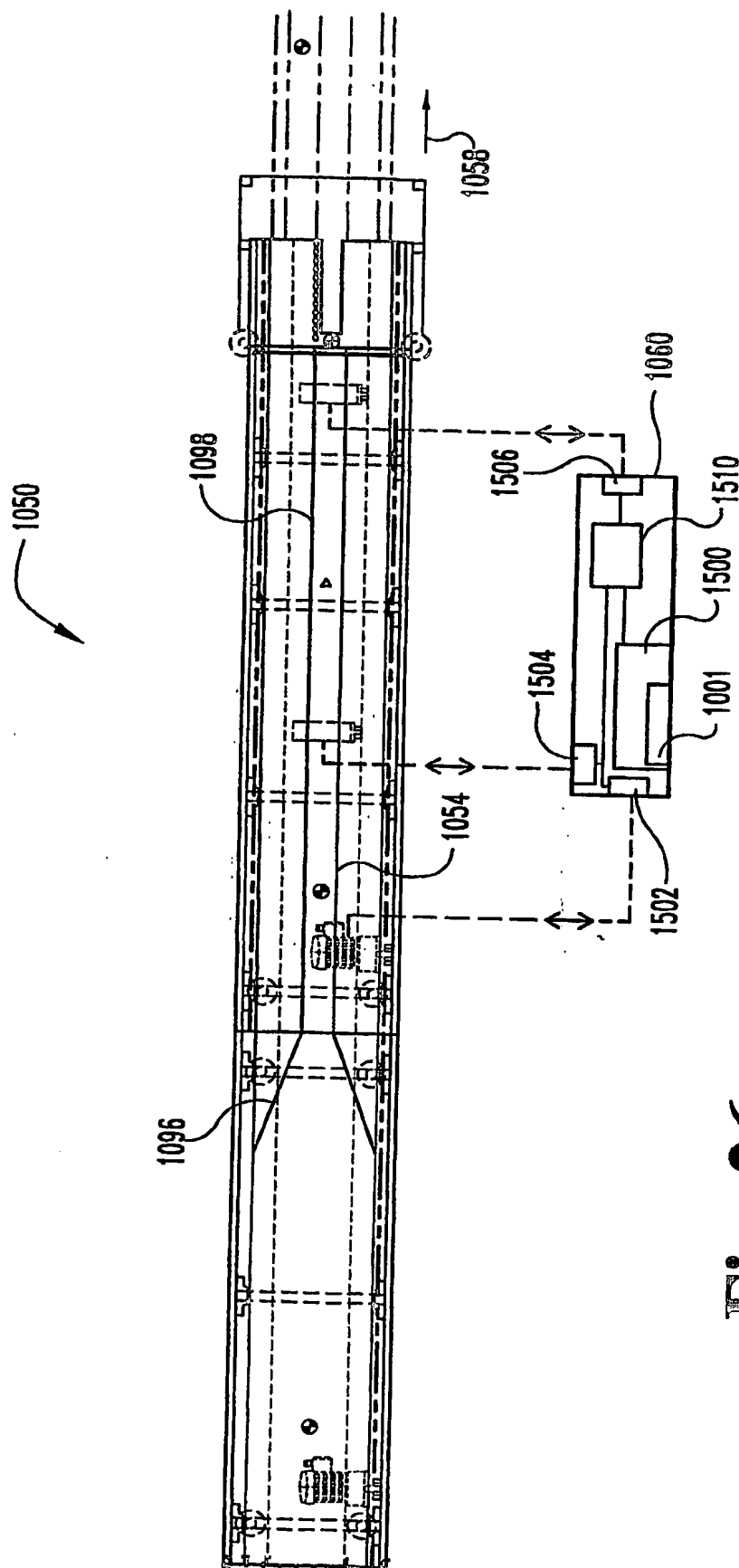
PitchOffset: Manual lug/pitch mark adjustment factor (in inches) entered via the OPI. Can be used to change the apparent position of the Lug/pitch mark sensor/signal instead of changing its actual physical position.

ScorrDist: Slave correction distance. Correction zone motor distance moved during a correction index.

McorrDist: Master correction distance. Master axis encoder distance remaining to be used to make the correction index.



**Fig. 25**



**Fig. 26**